Work Order ID 68032

Tuesday, April 05, 2011 2:18:43 PM

Item ID: D350-636-012 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Skidtube RH

Start Date: 4/5/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 4/25/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 11-04-5 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: IIN-D350-636 / Revision Nbr: H									
100	DOCUMENT CONTROL	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy blue file and type labels per PPP D350-636-012 CHG 006								

8 u/66/67

#1 for CL 11-6-6

B68032

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Item Name: Skidtube RH

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
Skidtubes		0.00							
Skidtubes									

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details).Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***

8-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Θpen up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB 11/05/17

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: M116577 BC 11/05/17 12-Grind welds flush as per Dwg D2750 DB 11/05/17								
120 QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00							
	Memo	0.00							
						11.05.18			
130 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
						11.05.18			

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Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00				1	0	M	11/05/18
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00				1	0	BE	11/05/18
Quality Control									

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
Skidtubes		0.00							

Skidtubes

Memo

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI-015
A/R ☐ Sikaflex-291 batch: 116948 ☐☐☐
exp. date: 12/8/15

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)
A/R☐ Aluminum Rod batch: M116577

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

BB 11/05/18

BB 11/05/18

BE 11/05/19

BE 11/05/19

BB 11/05/20

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	dwg D2750 12-Deburr holes	(1)							B 11/05/24
170 QC Quality Control	QC10- Inspect visual per QSI004- ground welds **Memo**	0.00 0.00							
180 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				(2)			

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3	0.00				1	BR	11-5-25.	
	Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00							
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005.4.3-Alum M116 9681	0.00				1	[illegible]	11-5-25.	
	Memo START TIME: 4:00 OVEN TEMPERATURE: 330° FINISH TIME: 4:20	0.00							
210 QC Quality Control	QC3- Inspect Part Finish	0.00				1	d	11/05/24	
	Memo ✓ Inspect for foreign object per QSI 024	0.00							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
HandFinish	HandFinishing					1	0		4/05/26
Hand Finishing	**Memo**	0.00							
	Install inserts as per dwg D2750								
230		0.00							
HandFinish	HandFinishing					1	0		
Hand Finishing	**Memo**	0.00							

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"
batch: N/A

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241
BATCH: M1166945
EXP DATE: 12101

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: M 114189

5-Coat all exposed fasteners with "LPS Procyon"
batch: M1142796

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00 11/05/31				(C)			
Quality Control									
250	Pick Kit	0.00							
Packaging	Memo	0.00				11/6/11			
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00 11/06/07				(C)			
Quality Control									

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270	Packaging	0.00							
Packaging									
Packaging	**Memo**	0.00							
Packaging	Package as per PPP D350-636-012								
280	QC21- Final Inspection - Work Order Release	0.00							
QC									
Quality Control	**Memo**	0.00							

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Picklist Print

Tuesday, April 05, 2011 2:18:48 PM

10

Work Order ID: 68032

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/5/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:I□02.09.25□Rearranged procedure steps□KJ□
IPP Rev:J 06-03-29 As per Rev D EC
IPP Rev:K 06-07.13 As per dsi9343 EC
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			220	Each	1,229.000	38	38			
Insert										HL 4/05/26			
				Location		**Loc Qty**		**Loc Code**					
				FP-B		148							
					110768	148				x38			
				ST282		1081							
					110768	1081							
AN3C5A		Purchased	No			230	Each	687.0000	34	34			
Bolt										HL 4/05/26			
				Location		**Loc Qty**		**Loc Code**					
				FP-A		7							
					115835	7							
				ST350		680							
					108302	28							
					115422	100							
					116419	452				x34			
					116549	100							

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Start Date: 4/5/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN3C6A	Purchased	No		230	Each	272.0000	4	4
BOLT								4 \| 4/05/26

Location	Loc Qty	Loc Code	
FP-A	41		
111982	41		
ST351	231		
111982	6		
116419	75		
116549	50		
116704	100		X4

AN6C44A	Purchased	No		230	Each	46.0000	4	4
BOLT								4/05/26

Location	Loc Qty	Loc Code	
FG	2	M117407	X4
103964	2		
ST344	44		
116874	44		

AN8C35A	Purchased	No		230	Each	42.0000	1	1
BOLT								4/05/26

Location	Loc Qty	Loc Code	
FP-A	42		
115188	1		
115960	18		X1
116874	23		

AN960C10L	NAS1149C0332R	Purchased	No	230	Each	0.0000	38	38
washer					M117291			(x38) 4/05/26

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Start Date: 4/5/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

AN960C816L	Purchased	No		230	Each	0.0000	1	1
WASHER								
D2745	Manufactured	No		230	Each	48.0000	8	8
Bushing								

Location	Loc Qty	Loc Code
FP-A	7	
63315	7	
ST021	41	
63315	41	

D3488-042	Manufactured	No		230	Each	17.0000	1	1
Blade Fitting Assembly, RH								

Location	Loc Qty	Loc Code
FP008	17	
59643	1	
62003	8	
65099	8	

D3492-041	Manufactured	No		230	Each	140.0000	8	8
Plug Assembly								

Location	Loc Qty	Loc Code
FP-B	140	
63994	4	
65068	20	
66937	116	

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Start Date: 4/5/2011 **Required Date:** 4/25/2011
Start Qty: 1.00 **Required Qty:** 1.00

D3492-043	Manufactured	No		230	Each	67.0000	8	8
Plug Assembly								

Location	Loc Qty	Loc Code
FP-B	67	B68252
66150	8	
66931	59	

D3535-25	Manufactured	No		230	Each	11.0000	1	1
Wearshoe								

Location	Loc Qty	Loc Code
FP018	11	
62233	1	B68353
65167	10	

D3536-25	Manufactured	No		230	Each	14.0000	1	1
Gasket								

Location	Loc Qty	Loc Code
FP012	14	
64446	2	
65903	12	

D3537-1	Manufactured	No		230	Each	24.0000	3	3
Wearpad								

Location	Loc Qty	Loc Code
FP017	24	~~B66804~~
63313	2	B68944
65927	22	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID: 68032
Parent Item: D350-636-012
Parent Item Name: Skidtube RH

Start Date: 4/5/2011 **Required Date:** 4/25/2011
Start Qty: 1.00 **Required Qty:** 1.00

D3631-1 Washer	Manufactured	No		230	Each	100.0000	8	8 MI 4/05/26

Location	Loc Qty	Loc Code	
ST072	100	B63647	x8
66959	100		

D3672-1 Phenolic Washer	Manufactured	No		230	Each	1,387.000	8	8 4 MI 4/05/26

Location	Loc Qty	Loc Code	
FP-A	37		
52505	37		
ST074	1350		
64177	850		x4
66821	500		

D3791-1 Wearplate	Manufactured	No		230	Each	10.0000	1	1 MI 4/05/26

Location	Loc Qty	Loc Code	
FP017	10		
~~62239~~	10		x1

D3793-1 Wearshoe	Manufactured	No		230	Each	17.0000	1	1 MI 4/05/26

Location	Loc Qty	Loc Code	
FP018	17		
61710	3		
64445	14		x1

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID: 68032

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/5/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3793-3	Manufactured	No		230	Each	12.0000	1	1
Wearshoe								11/05/26

Location	Loc Qty	Loc Code	
FP019	12		
61711	1		
64447	11		X1

D3794-1	Manufactured	No		230	Each	9.0000	1	1
Gasket								11/05/26

Location	Loc Qty	Loc Code	
FP010	9		
39279	1		
39421	1		
61704	7		X1

D3794-3	Manufactured	No		230	Each	11.0000	1	1
Gasket								11/05/26

Location	Loc Qty	Loc Code	
FP018	11		
39422	1		
61712	10		X1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 2:18:49 PM

Work Order ID: 68032

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/5/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

MS21043-6	Purchased	No		230	Each	575.0000	4	4
NUT								MH 11/05/26

Location	Loc Qty	Loc Code	
FG	20		
103693	20		
FP-A	80		
112314	80		
ST301	475		X4
112314	475		

MS21083C8	Purchased	No		230	Each	81.0000	1	1
NUT								MH 11/05/26

Location	Loc Qty	Loc Code	
FP-B	11		
115884	11		
ST303	70		
115884	0		
117010	20		
117291	50		X1

NAS1611-010	Purchased	No		230	Each	194.0000	8	8
O-RING								MH 11/05/26 PTG =)

Location	Loc Qty	Loc Code	
FP-A	194		
110915	147		
115589	47		

Dart Aerospace Ltd

W/O: 68032	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
11/05/26	230	Replace & Assemble NAS 1611-010 "O" rings with D2594-3 / M6 6952 (X8)	MH	11/05/26	X8		

Part No: D350-636-012 **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 2:18:49 PM

Work Order ID: 68032

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/5/2011 **Required Date:** 4/25/2011

Start Qty: 1.00 **Required Qty:** 1.00

NAS1611-013	Purchased	No		230	Each	192.0000	8	8

O-RING

Location	Loc Qty	Loc Code
FP	187	
117291	187	
FP-A	5	
116582	5	

AN8C21A	Purchased	No		250	Each	56.0000	2	2

BOLT

Location	Loc Qty	Loc Code
ST345	56	
116381	56	

AN960JD816	Purchased	No		250	Each	73.0000	2	2

1/2" washer,Alum

Location	Loc Qty	Loc Code
FP-A	73	
106043	73	

D2741	Manufactured	No		250	Each	66.0000	1	1

Blade, 350 Skidtube

Location	Loc Qty	Loc Code
ST466	66	
61341	26	
63589	40	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID: 68032
Parent Item: D350-636-012
Parent Item Name: Skidtube RH

Start Date: 4/5/2011 **Required Date:** 4/25/2011
Start Qty: 1.00 **Required Qty:** 1.00

D3493-1	Manufactured	No		250	Each	61.0000	2	2
Washer								

Location	Loc Qty	Loc Code	
ST062	61		
62677	21		
66975	40		2

D3532-1	Manufactured	No		250	Each	23.0000	2	2
Spacer								

Location	Loc Qty	Loc Code	
ST065	23		2
62218	23		

MS21083C8	Purchased	No		250	Each	81.0000	2	2
NUT								

Location	Loc Qty	Loc Code	
FP-B	11		
115884	11		
ST303	70		
115884	0		
117010	20		
117291	50		2

D2600-3-BENT	Manufactured	No		110	Each	9.0000	1	1
Extrusion Bent								

Location	Loc Qty	Loc Code	
LG	9		
66875	9		
68137			1

11/05/17

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID: 68032
Parent Item: D350-636-012
Parent Item Name: Skidtube RH

Start Date: 4/5/2011 **Required Date:** 4/25/2011
Start Qty: 1.00 **Required Qty:** 1.00

D2744	Manufactured	No		110	Each	45.0000	1	1
Cap								BE 11/05/19
		Location		**Loc Qty**	**Loc Code**			
		LG002		45				
			62715	16				
			65086	29				1
D2739	Manufactured	No		160	Each	6.0000	1	1
350 I Beam								
		Location		**Loc Qty**	**Loc Code**			
		LG 68285		6				1 BB 11/05/19
			66981	6				
D2743	Manufactured	No		160	Each	17.0000	8	8
Crossbolt Spacer								BE 11/05/19
								B 67766 -8
		Location		**Loc Qty**	**Loc Code**			
		LG001		17				
			64003	17				
D3490-3	Manufactured	No		160	Each	29.0000	4	4
Cross Bolt Spacer								BE 11/05/19
								B 67774 -4
		Location		**Loc Qty**	**Loc Code**			
		LG001		29				
			66968	29				
D3490-1	Manufactured	No		160	Each	23.0000	4	4
Cross Bolt Spacer								BE 11/05/19
								B 68105 -4
		Location		**Loc Qty**	**Loc Code**			
		LG001		23				
			62450	23				

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

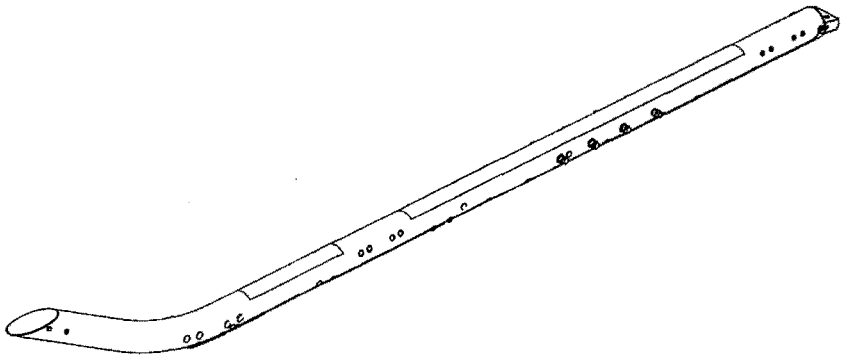
1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
2) FINISH:
 ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
8) WELD PER DART QSI 004
9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.287) FOR WEARSHOE INSERTS
10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL (F)
13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

RELEASED
05.22.17

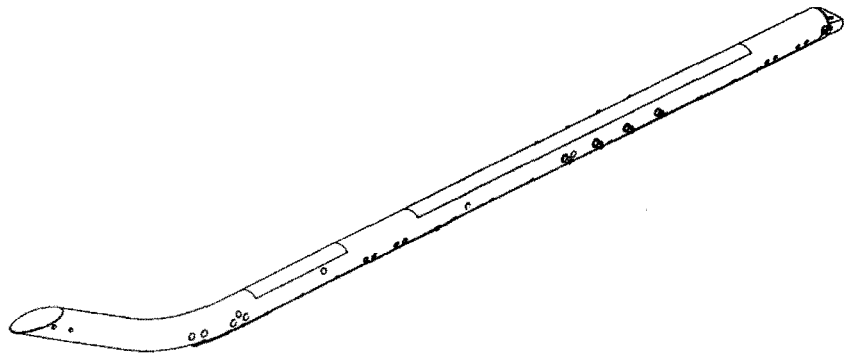
REV.	DESCRIPTION	BY	DATE
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3536-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H6L; REMOVE D2741, QTY (2) AN960C616; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16

DESIGN	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	PH	
CHECKED		DRAWING NO. D2750 REV. F
MFG. APPR.		SHEET 1 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.		
DATE	08.07.16	

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D2750-041 350 SKIDTUBE ASSEMBLY, LH

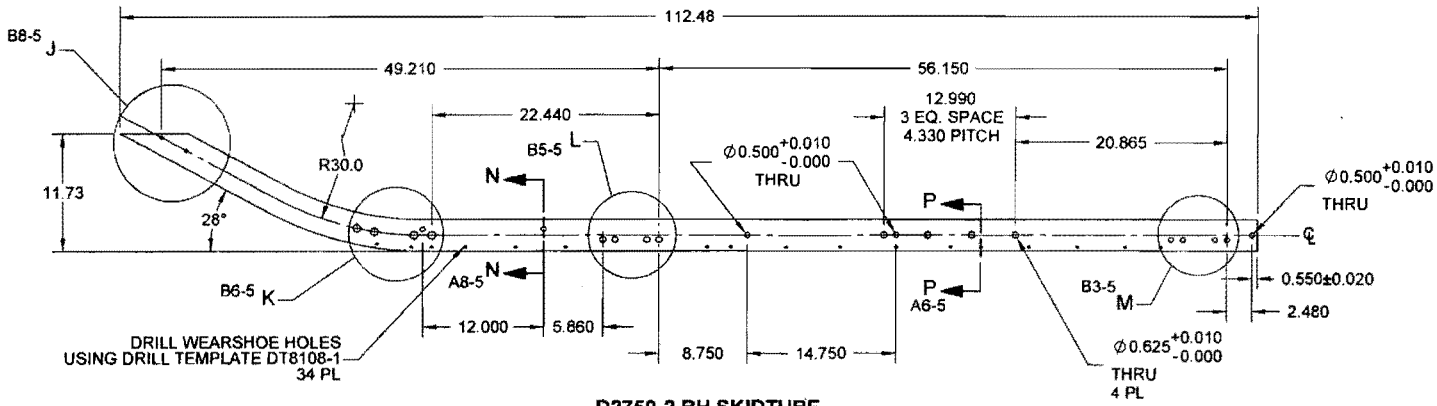


D2750-042 350 SKIDTUBE ASSEMBLY, RH

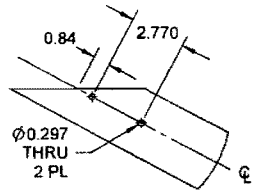
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DE 9.22.16

DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D2750 REV. F
MFG. APPR.		SHEET 2 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.		
DATE 08.07.16		

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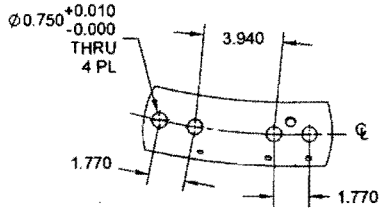


D2750-2 RH SKIDTUBE



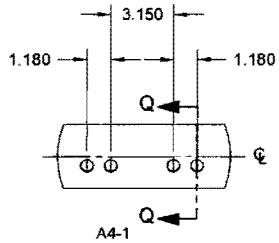
D8-5

DETAIL J
SCALE 2X



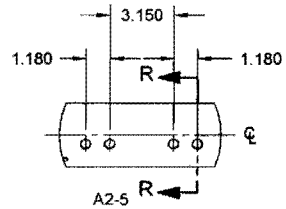
C7-5

DETAIL K
SCALE 2X



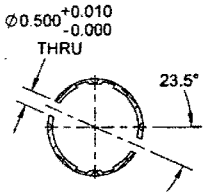
D6-5

DETAIL L
SCALE 2X



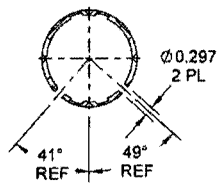
C3-5

DETAIL M
SCALE 2X



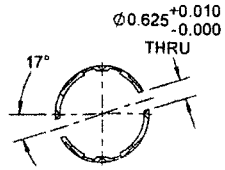
C6-5

SECTION N-N
SCALE 3X, 2 PL



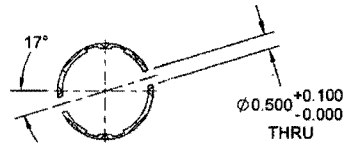
C4-5

SECTION P-P
SCALE 3X, 17 PL



B5-5

SECTION Q-Q
SCALE 3X, 4 PL



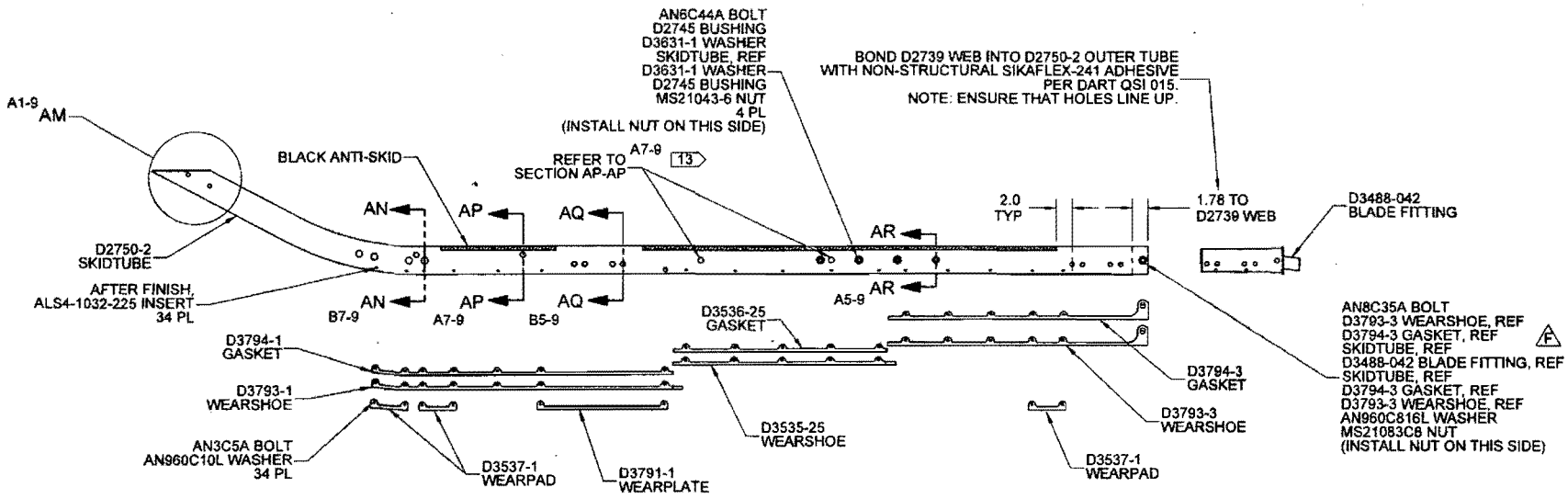
B3-5

SECTION R-R
SCALE 3X, 4 PL

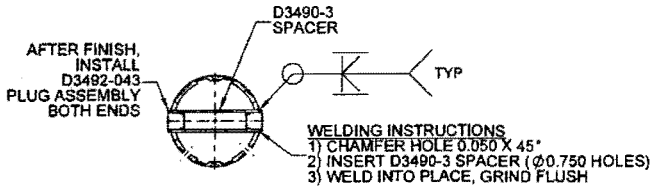
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MFG. APPR.		SHEET 5 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS
DE APPR.		
DATE 08.07.16		

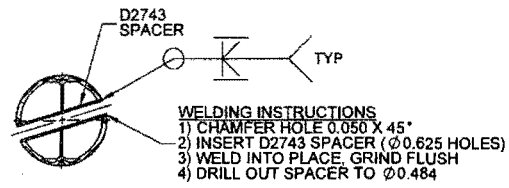
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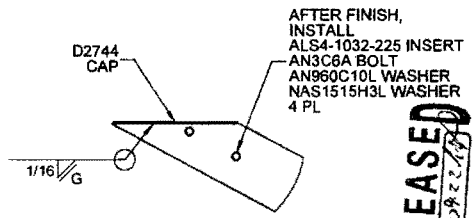
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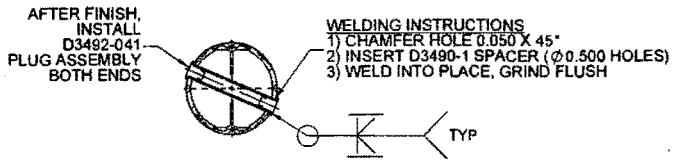
SECTION AN-AN C7-9
SCALE 3X, 4 PL



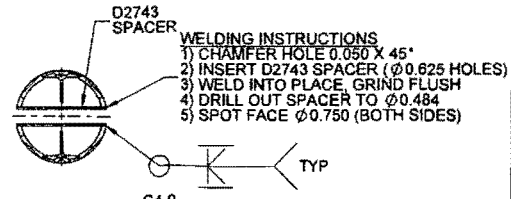
SECTION AQ-AQ C5-9
SCALE 3X, 4 PL



DETAIL AM D8-9
SCALE 2X



SECTION AP-AP C6-9, D5-9
SCALE 3X, 4 PL



SECTION AR-AR C4-9
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

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NO. 253

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 67621
Part number: 1350·636·011
Description: 350
Welding Process: Tig[X] Mig[]
Base materiel: Aluminum
Current: AC[X] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[X] fail[]
Penetration:	pass[X] fail[]

UNACCEPTABLE

Cracks:	pass[X] fail[]
Undercut:	pass[X] fail[]
Pin holes:	pass[X] fail[]
Overlap (cold lap)	pass[X] fail[]
Porosity (surface):	pass[X] fail[]
Coloration:	pass[X] fail[]

Qualifier Rob Lyons **Date of Test Coupon** 11·05·19

Welder Barclay Elliot **Date of Test Coupon** 11·05·19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld